Date: Thursday, 11/29/2007 11:07:07 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LATCH BRACKET
Job Number	: 36043		
Estimate Number	: 10994		
P.O. Number	: N/A	Part Number	: D2583
This Issue	: 11/29/2007 S.O. No. : N/A	Drawing Number	: D2583 REV. B
Prsht Rev.	: NO	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 33893	Material	: N/A
Written By	:	Due Date	: 12/6/2007 Qty: 100 Um: Each
Checked & Approved By	: AJ07.1129		
Comment	: Est: C 00.11.01 Removed P/O for Powder Coat- in house processDM		
	Est: D 06.07.21 Waterjet EC		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	M5052H32S040	5052-H32 .040 Sheet

13.?516

Comment: Qty.: 0.1227 sf(s)/Unit Total : 12.2745 sf(s)
Material: 5052-H32 (QQ-A-250/8) 0.040" thick
(M5052H32S040) Batch: 104971 B 07-12-04

2.0	WATER JET	FLOW WATER JET

Comment: FLOW WATER JET
1-Cut as per Dwg D2583
Dwg Rev: B B 07-12-4 (108)
Prog Rev: B

2-Deburr if necessary B 07-12-4

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE

B 07-12-4

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK

counts
A/12/66 +108

Comment: SECOND CHECK

5.0	BRAKE NC	NC BRAKE

Comment: NC BRAKE
Deburr ⟶
Form on CNC Brake as per Dwg D2583 07/12/06 (108)
SB 07/12/19 (108)

...art Aerospace Ltd

WORK ORDER CHANGES

W/O:							
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: 07/12/21

QA: N/C Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE (NCR)

NCR:							
DATE	STEP	Description of NC Section A	Corrective Action — Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services   **Drawing Name:** LATCH BRACKET

Job Number: 36043   **Part Number:** D2583

Job Number:

Seq. #:	Machine Or Operation:	Description :
6.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP   *12.19*   *QS P019*

| 7.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |

Comment: HAND FINISHING RESOURCE #1
Acid etch and Alodine as per QSI 005 4.1   *07.12.20*   *X108*

| 8.0 | POWDER COATING | POWDER COATING |

M 106379   *108X*

Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3   *M-L 07/12/20*

| 9.0 | QC3 | INSPECT POWDER COAT/CHEMICAL CONVERSION |

108

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION   *BL 07-12-20*

| 10.0 | PACKAGING.1 | PACKAGING RESOURCE #1 |

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: *222*   *1/12/20 SD 108*

| 11.0 | QC21 | FINAL INSPECTION/W/O RELEASE |

108

Comment: FINAL INSPECTION/W/O RELEASE   *07/12/21*

Job Completion   *2007/12/21*

Dart Aerospace Ltd

WORK ORDER CHANGES

W/O:							
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE (NCR)

NCR:			Corrective Action Section B					
DATE	**STEP**	**Description of NC** Section A	**Initial** Chief Eng	**Action Description** Chief Eng	**Sign & Date**	**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	36043
Description: Latch Bracket		**Part Number:**	D2583
Inspection Dwg: D2583 **Rev:** B			Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] **First Article** [ ] **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.188	+/-0.010	3.180	X			
3.380	+/-0.010	3.377	X			
0.907	+/-0.010	.907	X			
1.725	+/-0.010	1.723	X			
R0.125	+/-0.010	.125	X			
0.980	+/-0.010	.981	X			

Measured by:	HB	Audited by:	_(signature)_	Prototype Approval:	N/A
Date:	07-12-4	Date:	17/12/06	Date:	N/A

Rev	Date	Change		Revised by	Approved
A	04.06.25	New Issue		KJ/JLM	

DESIGN	DRAWN BY	DART AEROSPACE LTD	
MIKE M.	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
CP	KE	D2583	SHEET 1 OF 1
DATE		TITLE	SCALE
99.02.22		LATCH BRACKET	2:3
A	96.07.10	NEW ISSUE	
B	99.02.22	CHANGE OF FINISH (PER TSR A887)	

KE 99.02.26

220

2.150

R0.125 (TYP 2 PLACES)

1.725

0.373

R0.125 (TYP)

4.571

3.380

0.907

R0.125 (TYP)

0.980

0.600 (TYP)

R0.125 (TYP)

43°

R0.188 BEND RELIEF (TYP)
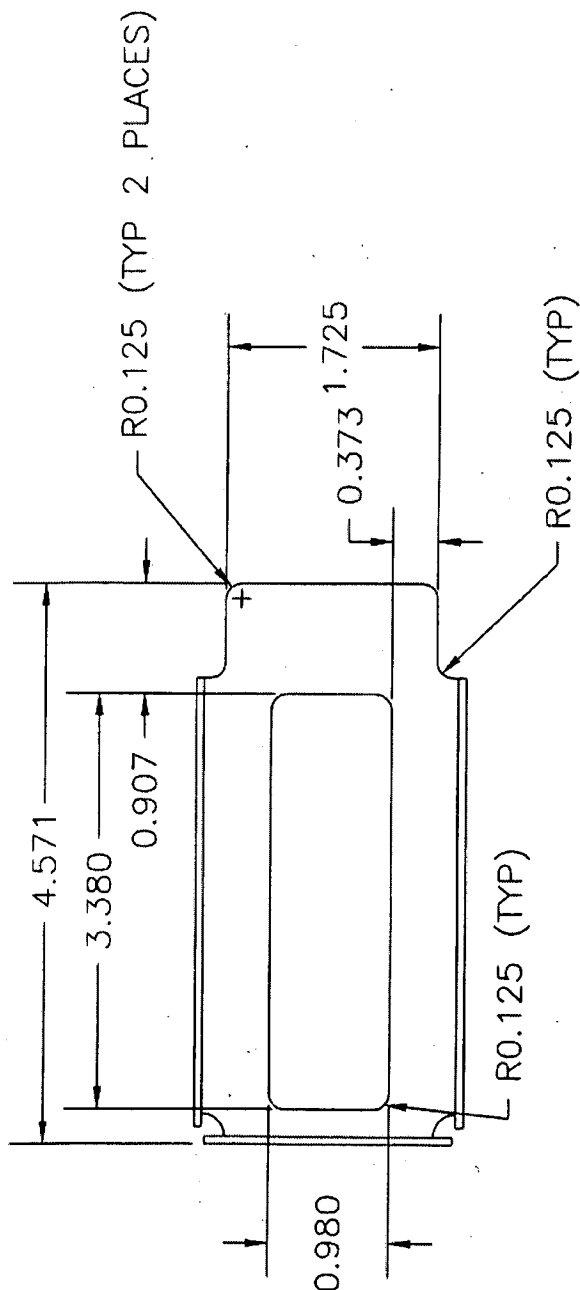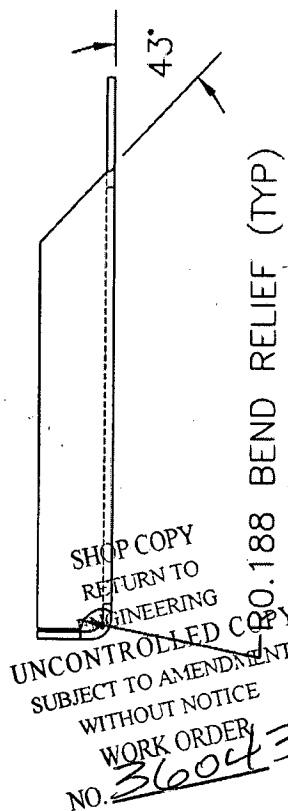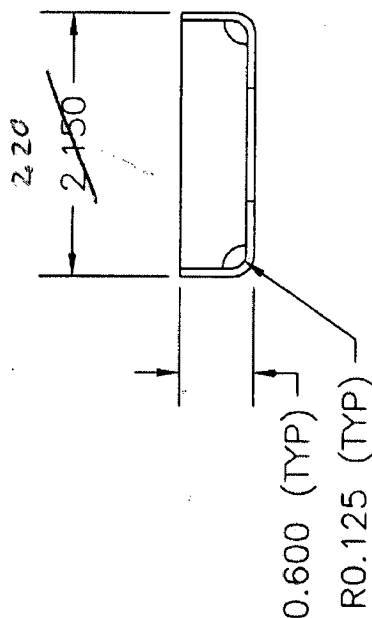
MATERIAL: 5052-H32 (QQ-A-250/8) 0.040 THICK
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

WORK ORDER
NO. 36043